

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017325**Date Inspected:** 29-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tian Lei.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Subassembly, Bay 02, Steel Barrier.

FCAW welding of weld joint E5-SB1-053-001, 002, 003; located on assembly, Bay 02. Welder is identified as 207465; ZPMC Quality Control Inspector (QC) is identified as Tian Lei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133.

Subassembly, Bay 02, 13 W, Vertical plate.

FCAW Repair welding of weld joint VP3015-001-010(WRR # B-WR15215); located at Subassembly, Bay 02. Welder is identified as 045240; ZPMC Quality Control Inspector (QC) is identified as Tian Lei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-FCM-REPAIR-1.

Subassembly, Bay 07, CB19, Edge Webber plate.

FCAW welding of weld joint X4253A-004-001; located on Subassembly, Bay 07. Welder is identified as 053742; ZPMC Quality Control Inspector (QC) is identified as Xu Xian Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F-2.

This QA Inspector carried out NDE on following
OBG Segment 10CW-11AW.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector performed verification Ultrasonic Testing (ABF Request No: UT-11W-028) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. . The location of the inspection was identified as the hold back welds between side panel and edge panel of OBG segment 11AW at intersection of OBG segment 10CW-11AW on counter weight side. The weld designations were;

CA079-002. (10CW-11AW, DP to EP-W2, CW side).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
